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S 148888

D3488-4
Job Sheet 187883-A



Part No: D3488-4

Job Qty: 1 pcs

Part Name: Blade Fitting, RH



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 1/29/19

Job Tracking No:

Due Date: 1/4/19

Created By: Jason Leroux

Type: SOLD

Description:

Note: DSK101 REV.D / D3488 REV.C IPP REV:A 18.11.09 NEW ISSUE DD VERF:JFS

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
110	QC 2	1 pcs		1/4/19	0.00	0.00	QC 2 - 1		
120	HAAS 4 Axis - B4B	1 pcs		1/4/19	0.11	0.69	HAAS - 1 - B4B		
							HAAS - 2 - B4B		
							HAAS - 3 - B4B		SBL 19/01/30
							HAAS - 4 - B4B		
130	QC 2	1 pcs		1/4/19	0.00	0.00	QC 2 - 1		
							QC 2 - 12		
							QC 2 - 14		
							QC 2 - 17		
							QC 2 - 19		
							QC 2 - 2		
							QC 2 - 20		
							QC 2 - 22		
							QC 2 - 23		
							QC 2 - 25		
							QC 2 - 32		
							QC 2 - 33		
							QC 2 - 35		
							QC 2 - 38		
							QC 2 - 39		
							QC 2 - 4		
							QC 2 - 40		
							QC 2 - 44		
							QC 2 - 45		
							QC 2 - 48		
							QC 2 - 49		
							QC 2 - 50		
							QC 2 - 51		
							QC 2 - 52		
							QC 2 - 54		
							QC 2 - 56		
							QC 2 - 57		SBL 19/01/30

140 QC 8	1 pcs	1/4/19	0.00 0.00	QC 2 - 62	
				QC 2 - 63	
				QC 2 - 8	
				QC 8 - 12	
				QC 8 - 14	
				QC 8 - 17	
				QC 8 - 20	
				QC 8 - 25	
				QC 8 - 3	
				QC 8 - 32	
				QC 8 - 33	
				QC 8 - 35	
				QC 8 - 38	
				QC 8 - 39	
				QC 8 - 4	
				QC 8 - 44	
				QC 8 - 45	
				QC 8 - 49	
				QC 8 - 58	
				QC 8 - 8	
				QC 8 - 9	
				QC 8 - 68	
				QC 8 - 67	
				QC 8 - 1 (A)	
150 Handfinish - 1-1 Chemical- B4B	1 pcs	1/4/19	0.00 0.03	Handfinish - 1 - 1 - B4B	
				Handfinish - 1 - 2 - B4B	
				Handfinish - 1 - 3 - B4B	
				Handfinish - 1 - 4 - B4B	
				Handfinish - 1 - 5 - B4B	
				Handfinish - 1 - 6 - B4B	
				Handfinish - 1 - 7 - B4B	
				Handfinish - 1 - 8 - B4B	
				Handfinish - 1 - 9 - B4B	
				Handfinish - 1 - 10 - B4B	
				Handfinish - 1 - 11 - B4B	
				Handfinish - 1 - 12 - B4B	
				Handfinish - 1 - 13 - B4B	
				Handfinish - 1 - 14 - B4B	
				Handfinish - 1 - 15 - B4B	
				Handfinish - 1 - 16 - B4B	
				Handfinish - 1 - 17 - B4B	
				Handfinish - 1 - 18 - B4B	
				Handfinish - 1 - 19 - B4B	
				Handfinish - 1 - 20 - B4B	
				Handfinish - 1 - 21 - B4B	
				Handfinish - 1 - 22 - B4B	
160 Powdercoat - 1 White GI(A)- B4B	1 pcs	1/4/19	0.00 0.04	Powdercoat - 1 - B4B	
				Powdercoat - 2 - B4B	
				Powdercoat - 3 - B4B	
				Powdercoat - 4 - B4B	

2/19/01/30

D.R. 19/01/30

B.F. B.A. 01-30

170 QC 3

1
pcs

1/4/19

0.00 0.00

QC 3 - 10

QC 3 - 13

QC 3 - 15

QC 3 - 17

QC 3 - 18

QC 3 - 2

QC 3 - 26

QC 3 - 28

QC 3 - 3

QC 3 - 30

QC 3 - 34

QC 3 - 36

QC 3 - 38

QC 3 - 41

QC 3 - 51

QC 3 - 58

QC 3 - 59

QC 3 - 6

QC 3 - 68

QC 3 - 9

JL 19-1-30

200 Packaging 3-1 - Stock - B4B

1
pcs

1/4/19

0.00 0.00

Packaging 3 - 1 - B4B

Packaging 3 - 2 - B4B

Packaging 3 - 3 - B4B

Packaging 3 - 4 - B4B

Packaging 3 - 5 - B4B

Packaging 3 - 6 - B4B

Packaging 3 - 7 - B4B

Packaging 3 - 8 - B4B

Packaging 3 - 9 - B4B

Packaging 3 - 10 - B4B

Packaging 3 - 11 - B4B

Packaging 3 - 12 - B4B

Packaging 3 - 13 - B4B

Packaging 3 - 14 - B4B

Packaging 3 - 15 - B4B

Packaging 3 - 16 - B4B

Packaging 3 - 17 - B4B

Packaging 3 - 18 - B4B

Packaging 3 - 19 - B4B

Packaging 3 - 20 - B4B

Packaging 3 - 21 - B4B

Packaging 3 - 22 - B4B

Packaging 3 - 23 - B4B

Packaging 3 - 24 - B4B

Packaging 3 - 25 - B4B

Packaging 3 - 26 - B4B

Packaging 3 - 27 - B4B

Packaging 3 - 28 - B4B

Packaging 3 - 29 - B4B

Packaging 3 - 30 - B4B

Packaging 3 - 31 - B4B

Packaging 3 - 32 - B4B

Packaging 3 - 33 - B4B

Packaging 3 - 34 - B4B

Packaging 3 - 35 - B4B

Packaging 3 - 36 - B4B

FP-001

JL 19-1-30

210 QC 21 - SA

1
pcs

1/4/19

0.00 0.00

QC 21 - SA - 21

QC 21 - SA - 70

DAG

21

JAN 30 2019

Part Op 110 - QC2 Machining-2 (QC2- Inspect parts off machine FAI/FAIB)

Descriptions: 120 - HAAS1-3 (HAAS CNC Vertical Machine) 1-Machine as per Folio FA627 & Dwg D3488

130 - QC2 Machining-2 (QC2- Inspect parts off machine FAI/FAIB)

140 - QC8 Machining-2 (QC8- Inspect parts - second check)

150 - HandFinish1 (Chemical Conversion Coat per QSI005 4.1)

M138997 160 - Powdercoat1 (White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum) START TIME: 10:20 OVEN TEMPERATURE:
320 FINISH TIME: 10:50

170 - QC3 (QC3- Inspect Part Finish)

200 - Packaging3-1 (Identify as per dwg & Stock Location: LOCATION : FP001

210 - QC21 (QC21- Final Inspection - Work Order Release)

Job BOM

Job BOM records could not be found.

Job Allocations

Job Allocations could not be found.

Part Specifications

Specifications could not be found.

Plex 1/29/19 8:36 AM dart.leroux.jason

DART AEROSPACE LTD		Work Order: 187883
Description: Blade Fitting, RH / Turning Detail for D3488-1/-2		Part Number: D3488-4
Inspection Dwg: D3488 / DSK101 Rev: C / D		Page 1 of 2

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Lathe Section						
Ø2.150	+/-0.005	2.152				
Ø2.780	+/-0.005	2.779				
Ø3.125	+/-0.010	3.124				
Ø3.346	+/-0.010	3.3465				
0.125 x 45°	+/-0.010 x +/-0.1°	120 x 45°				
8.000	+0.030/-0.000	8.008				
9.250	+/-0.010	9.251				
0.188	+/-0.010	.188				
R0.032	+/-0.010	R.032				
R0.062	+/-0.010	R.062				
Ø0.297	+0.005/-0.001	X				
Ø0.430	+/-0.010					
0.100	+/-0.010					
0.200	+/-0.010					
2.620	+/-0.010	2.619				
3.500	+/-0.010	X				
1.005	+/-0.010					
Ø0.484	+0.005/-0.001	.486				
1.180	+/-0.010	1.180				
3.150	+/-0.010	3.150				
3.070	+/-0.010	3.065				
R0.063	+/-0.010	R.063				

DART AEROSPACE LTD	Work Order:	187883
Description: Blade Fitting, RH / Turning Detail for D3488-1/-2	Part Number:	D3488-2-4
Inspection Dwg: D3488 / DSK101 Rev: C / D		Page 2 of 2

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Milling Section						
Ø0.508	+0.006/-0.001	.508	✓			
0.750	+/-0.010	.750	✓			
1.500	+/-0.010	1.500	✓			
11.18	+/-0.030	11.177	✓			
R0.062	+/-0.010	.062	✓			
0.125	+/-0.010	.125	✓			
0.590	+/-0.010	.590	✓			
0.793	+/-0.010	.798	✓			
1.351	+/-0.010	1.353	✓			
1.317	+/-0.010	1.318	✓			
1.802	+/-0.010	1.799	✓			

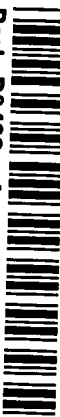
Measured by: SBC	Audited by: [Signature]	Prototype Approval:	N/A
Date: 19/01/24	Date: 19/01/30	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	06.03.31	New Issue	KJ/JLM	
B	08.09.19	Reformat P/O D3488-042	KJ/JLM	
C	08.12.02	Dimension 8.000 removed	KJ/JLM	
D	18.11.22	Dimension 0.125 changed to 0.200	MS [Signature]	M

DAR I **AEROSPACE**

Container No: S14888

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Part: D3488-4

Job No: 187883-A

Serial No/Batch: S147798

Revision: D/C

Inspector:

Exp Date:

Instructions:

Date: 01/30/19